

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022058**Date Inspected:** 18-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 039 located at PCMK SEG3019BB. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u5b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 153 located at PCMK SEG3019Q-1. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-Fcm-1.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 070007 performing the Shielded Metal Arc Welding process on weld 097 located at PCMK SEG3019AW. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-Fcm-Repair-1. Weld repair report identified as B-WR20418.

Installation/ erection of the FB3291 and FB3290 were in process in OBG lift 14 East. See attached photo.

## OBG 13 EAST

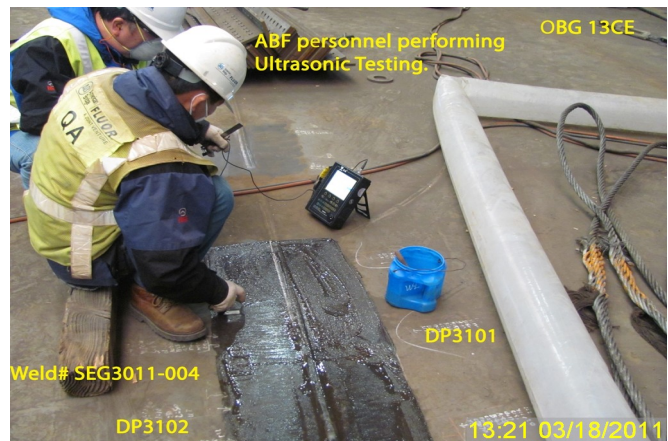
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051359 performing the Shielded Metal Arc Welding process on weld 019 located at PCMK DP3089-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u5b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066263 performing the Flux Cored Arc Welding process on weld 027 located at PCMK VP3007-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068920 performing the Flux Cored Arc Welding process on weld 069 located at PCMK VP3007-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic testing on the repair areas of the weld joint between DP3101 and DP3102. Weld number identified as SEG3011-004.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials

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for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Patterson,Rodney

QA Reviewer